

Date: Tuesday, 11/29/2005 7:14:48 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRAP
Job Number	: 25048B		
Estimate Number	: 10729		
P.O. Number	: N/A	Part Number	: D23245
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Number	: D2324 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 24528B	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/6/2005
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Qty:	42 40 Um: Each
Comment	: Est. E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: PO 000000186

05/11/30

Email or ship DXF file to vendor

Laser cut flat pattern per Dwg D2324

Material release note required

2.0	D23245F	Strap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

STRAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

06/01/17

46

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

06-01-17 46

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

JAD 06/01/31

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 13 Date: 06/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services



Drawing Name: STRAP

Job Number: 25048B

Part Number: D23245

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1 	PACKAGING RESOURCE #1 
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 37

06/01/23 (42)

7.0	DC 	DOCUMENT CONTROL 
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Comment: DOCUMENT CONTROL
Inspection Level 21 SUR 06/01/26 (42) 06/01/24

Job Completion 

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

90250188

INSPECTION CERTIFICATE MATERIAL TEST/INSPECTION CERTIFICATES

YEH MAU CORP.

INVOICE NO.:
COMMODITY:

FORM 71
FEDERAL COLD ROLLED STAINLESS STEEL SHEET AISI 304/304 (SIC)
FINISH WITH 160 MIC. FILM ON MAIN SIDE, WITH BACK-FINISH,
SLITTED EDGE AND 304/304 FINISH WITH PAPER INTERLEAVED,
SLITTED EDGE.

DESCRIPTION:
CUSTOMER:

INTEGRIS METALS LTD

工廠:高雄縣橋南鄉安港路345號
345 SHUN AN RD. LI CHU HSIANG
KACHUNG TAIWAN R.O.C.
TEL: 8778878005 FAX: 8778878008
CERTIFICATE NO: 90250188
DATE OF ISSUE: 05/19/2004

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	SI x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AB1 304 2B (7425-4228) 16GA48"X120" (7425-6351)	1	1,473	3,247	YU132553	34321644B-4	265	808	58	81	150	3.9	48	115	24	4	807	1827	3.2
16GA48"X120" (7425-6351)	1	1,445	3,186	YU228940	34321938B-5	280	880	57	80	158	4.2	48	118	24	8	829	1828	2.8
12GA48"X120" (7425-6310)	1	1,457	3,212	YU228245	35522525A-3	285	835	54	82	159	4.5	48	126	30	3	815	1827	2.5
12GA48"X120" (7425-2840)	1	1,435	3,164	YU131855	35522522A-2	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2
12GA48"X120" (7425-2840)	1	1,435	3,164	YU131855	35522522A-3	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2
12GA48"X120" (7425-2840)	1	1,414	3,117	YU131855	35522522A-4	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2
12GA48"X120" (7425-2840)	1	1,480	3,283	YU228628	35523009A-4	277	855	54	77	145	4	47	112	28	4	821	1815	2.0
16GA48"X120" (7425-6351)	1	1,437	3,186	YU229031	35522903C-5	298	860	53	82	160	4.2	49	114	32	5	810	1813	1.7
12GA48"X120" (7425-6351)	1	1,430	3,153	YU132680	35523001B-11	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.6
12GA48"X120" (7425-6351)	1	1,430	3,153	YU132680	35523001B-9	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.6
12GA48"X120" (7427-3540)	1	1,391	3,087	YU132680	35523001B-12	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.6
12GA48"X120" (7427-3540)	1	1,465	3,230	YU228945	35523007A-12	306	855	53	83	165	4.9	45	108	24	5	817	1824	3.1
12GA48"X120" (7427-3540)	1	1,371	3,023	YU228945	35523007A-13	306	855	53	83	165	4.9	45	108	24	5	817	1824	3.1
12GA48"X120" (7427-3540)	1	1,375	3,031	YU228945	35523007A-14	306	855	53	83	165	4.9	45	108	24	5	817	1824	3.1
12GA48"X120" (7427-3540)	1	1,375	3,031	YU228945	35523007A-15	306	855	53	83	165	4.9	45	108	24	5	817	1824	3.1
12GA48"X120" (7427-3540)	1	1,423	3,137	YU132689	35523083A-11	294	846	53	82	161	5.2	51	115	31	3	802	1823	2.8

NO MERCURY CONTAMINATION
Send test report for all Heat NO.

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE

PRODUCT IN ACCORDANCE WITH ASTM A240, A430,
A367E, ASME SA340, Q35700D.

YEH MAU CORP.

Lin Kim Hsing
Manager of Quality Assurance Section

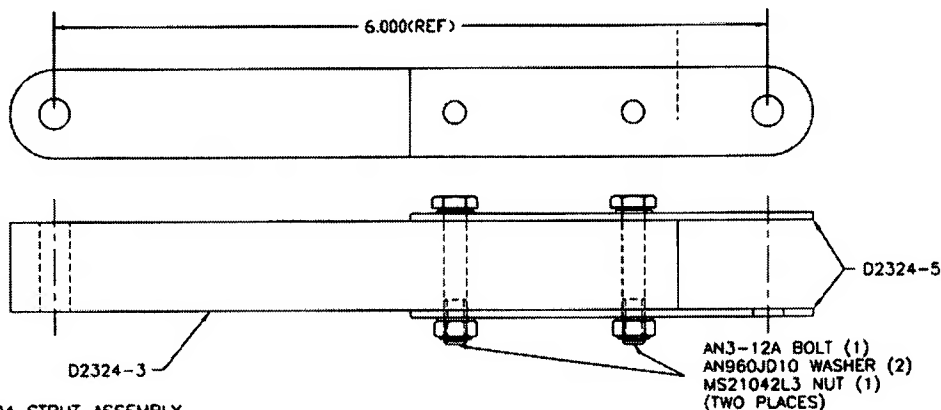
1694 304 4 S

66-017

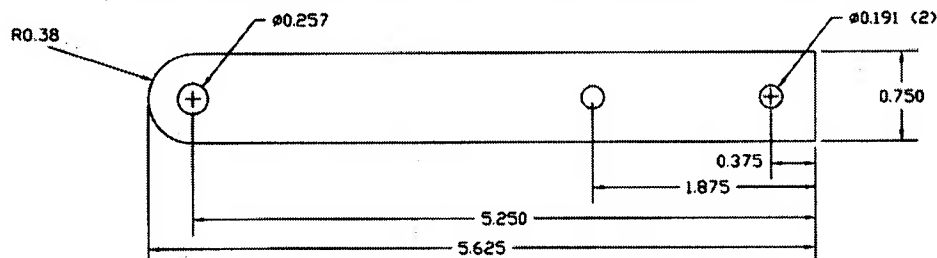
100# 186, 184, 146

DART

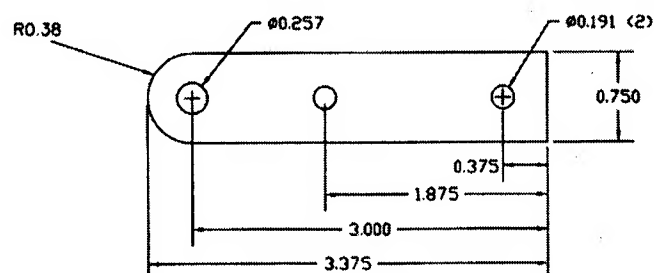
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED